

Date: Monday, 11/08/2008 2:11:20 PM  
User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SEAT RAIL
Job Number	41117	Part Number	D38081
Estimate Number	13533	Drawing Number	D3808 PREL Rev. A
P.O. Number		Project Number	N/A
This Issue	11/08/2008	Drawing Revision	<u>PREL</u> Rev. A
Prsht Rev.	NC	Material	
First Issue	11	Due Date	18/08/2008
Previous Run		Qty:	4
Written By	<u>Jean-Luc Menard</u>	Um:	Each
Checked & Approved By		POSITIVE RECALL	
Comment	Est Rev. A, New Issue 08-07-31 JLM Verified By:DD		

## Additional Product

## PRELIMINARY ISSUE

Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B2000X01250	6061-T6 Bar 2.00 x 1.25 	
Comment: Qty.: 1.4175 f(s)/Unit Total: 5.6700 f(s) 6061-T6 Bar 2.00 x 1.25 Batch: M105411		N/A 08/08/13 (5)	
2.0	BAND SAW	BAND SAW 	
Comment: BAND SAW Cut blank 16.125" long		N/A 08/08/13 (6)	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 	
Comment: HAAS CNC VERTICAL MACHINING #1		8/10 (8/10)	
1- Mill as per Folio FA771Rev: <u>A</u> & Dwg D3808 Rev: <u>Prelim rev. A.</u> 2-Tap holes for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 4-Deburr per dwg D3808			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		8/8 08/08/14 (6)	

Dart Aerospace Ltd

## WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval	Approval
DATE	STEP					Chief Eng / Prod Mgr	QC Inspector

Part No: D3808-1 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: SD Date: 08/10/10  
D3808-0411/DS19419-011 QA: N/C Closed: SD Date: 08/10/10

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/13	3.0	Took the origin on the wrong side of the blank Q.C: Operator error. LACK of Attention.	<u>MA</u>	<ul style="list-style-type: none"> <li>- Rule was clear in all instructions.</li> <li>- Scrap &amp; replace after 1 <del>1000001</del></li> </ul>	<u>M.A</u> 08/08/13	<u>SD</u> 08/08/22	<u>SD</u> 08/08/22	<u>SD</u> 08/08/22

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT RAIL

Job Number: 41117

Part Number: D38081

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 MILLING CONV.



CONVENTIONAL MILLING MACHINE

?

Comment: CONVENTIONAL MILLING MACHINE  
1-DRILL REMAINIG HOLESN/A *Guill*

6.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A *Guill*

7.0 QC8



SECOND CHECK

ENGINEERING  
APPROVAL

Comment: SECOND CHECK

J-F. 08/08/15

5

8.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/08/15 5

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*W041238**W*

10.0 QC21



FINAL INSPECTION/W/O RELEASE



08/08/15 8

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

*U 08/08/20*POSITIVE RECALL  
EFFECTIVE 08/08/11  
RELEASED *pe* 08/08/20*RS* 08.08.20

DART AEROSPACE LTD	Work Order:	41117
Description: <i>Seat Rail</i>	Part Number:	D3808-1
Inspection Dwg: Rev: Prelim A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000		14.000	✓			
7.30		7.302	✓			
15.88		15.88	✓			
5.130		5.130	✓			
6.13		6.130	✓			
2.00		2.005	✓			
1.75		1.751	✓			
.550		.552	✓			
.85		.852	✓			
.780		.777	✓			
.16		.163	✓			
$\phi 32.3 \pm 0.005$		$32.2 \times .695$	✓			
.172		.171	✓			
.3800x.667		.800x.670	✓			
.373		.380	✓			
.140		.145	✓			
.347		.347	✓			
.350		.349	✓			
.655	$+.015$ $-.010$	.657	✓			
.320	$+.020$ $-.006$	.325	✓			
.720	$+.005$ $-.010$	.721	✓			
.270	$+.030$ $-.000$	.272	✓			
.323		.322				

Measured by:	<i>JS</i>	Audited by:	<i>J.F.</i>	Prototype Approval:	<i>AA</i>
Date:	<i>08/08/114</i>	Date:	<i>08/08/15</i>	Date:	<i>08.08.20</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

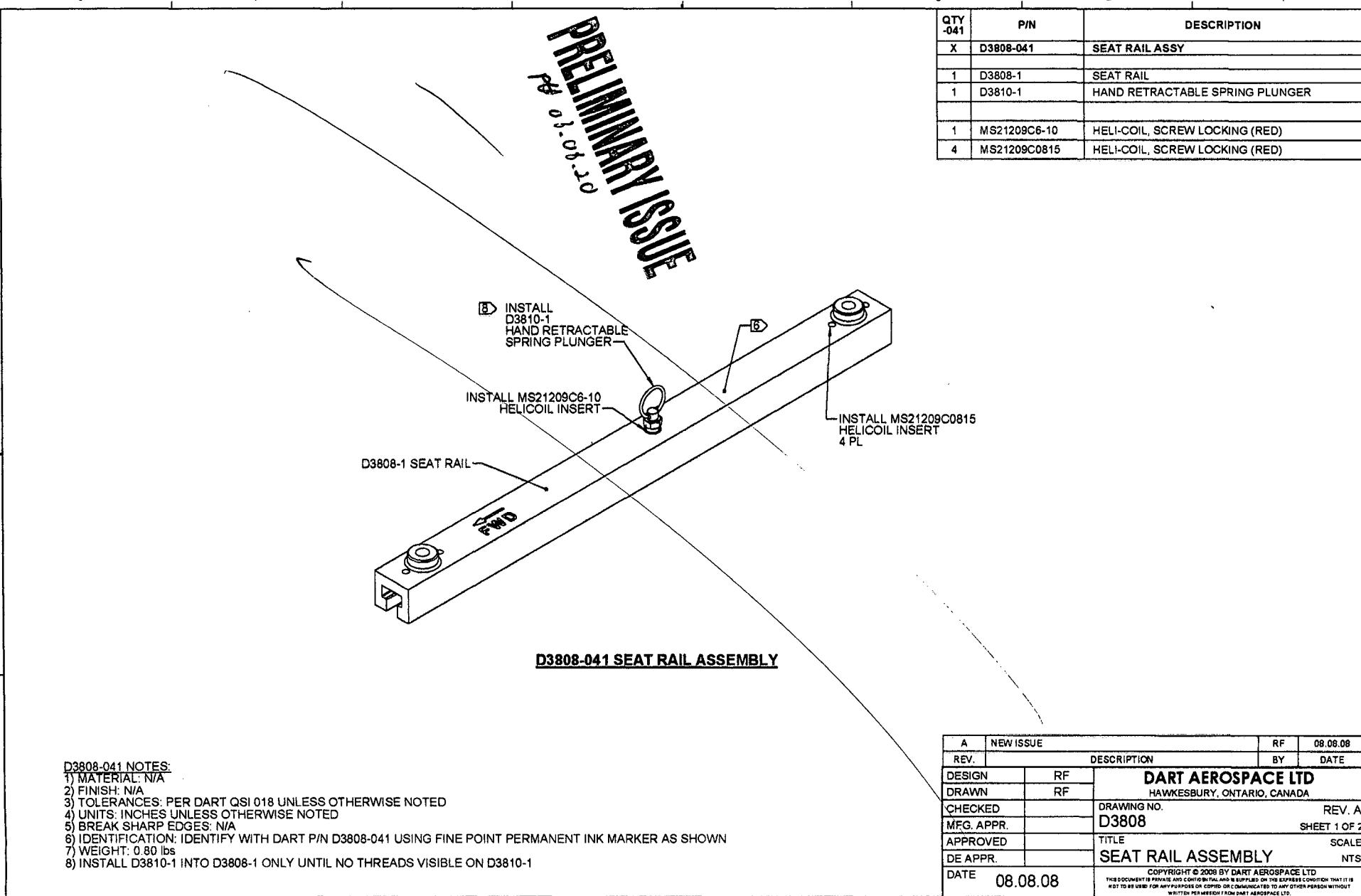
DART AEROSPACE LTD	Work Order:	41117
Description: Seat Rail	Part Number:	D3808-1
Inspection Dwg:	Rev: Prelim A	Page 2 of 1

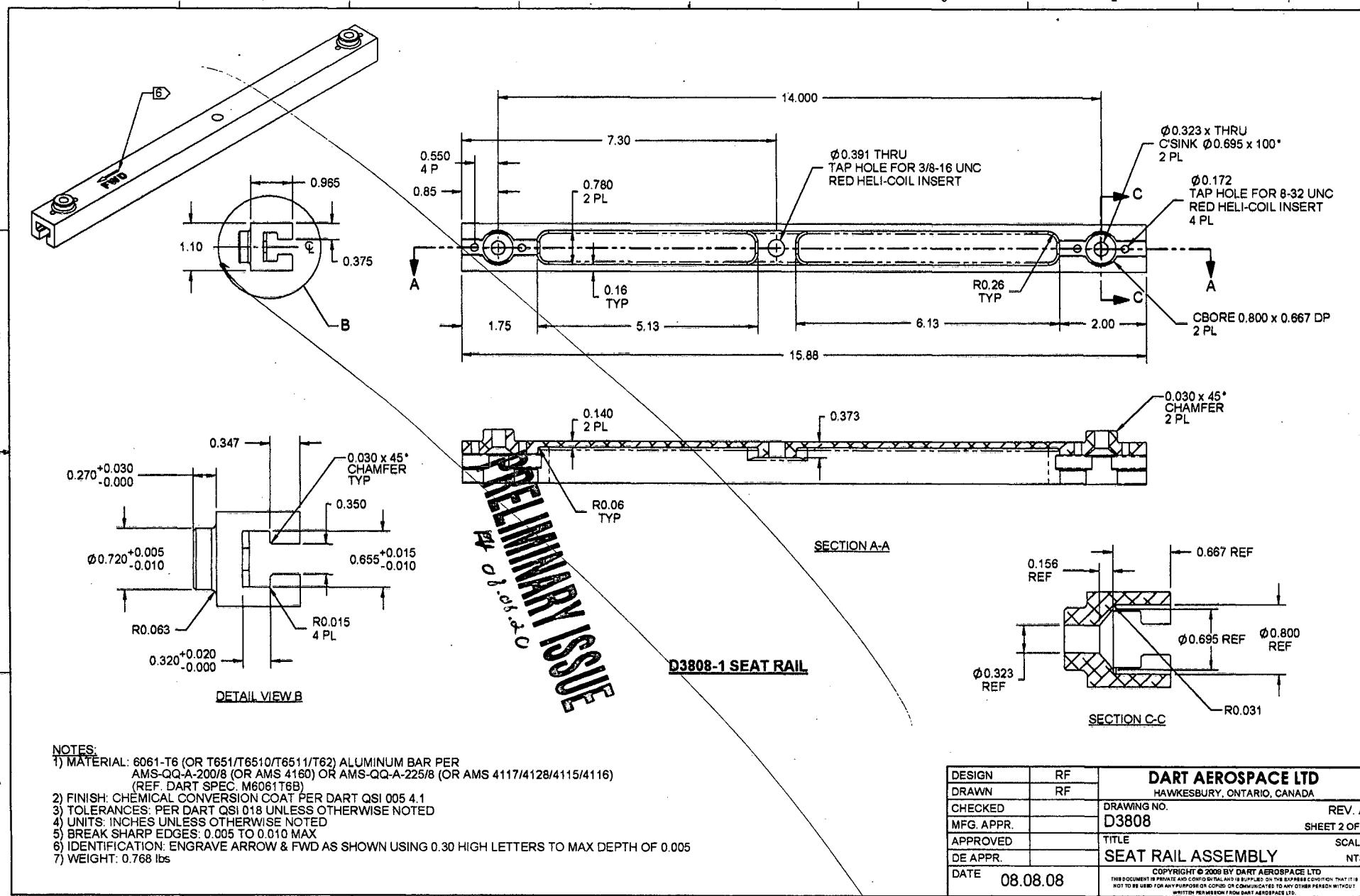
## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by: <u>J.S.</u>	Audited by: <u>J.F.</u>	Prototype Approval: <u>Ref</u>
Date: <u>08/08/14</u>	Date: <u>08/08/15</u>	Date: <u>08.08.20</u>

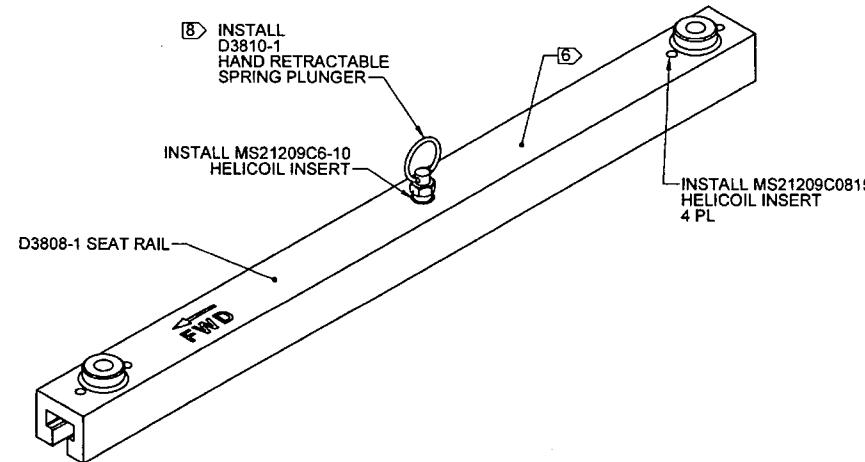
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





8 7 6 5 4 3 2 1

QTY	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

RELEASED  
08-08-08

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

100-01-80  
100-01-80  
100-01-80  
100-01-80

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. <b>D3808</b>	
CHECKED		REV. A SHEET 1 OF 2	
MFG. APPR.		TITLE <b>SEAT RAIL ASSEMBLY</b>	
APPROVED		SCALE NTS	
DE APPR.			
DATE	<b>08.08.08</b>		

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8 7 6 5 4 3 2 1

